

Work Order ID 59998

June 22, 2010 2:31:53 PM



Page 1

Item ID: D4051-1

Accept



Setup

Start



Revision ID:

Stop



Item Name: Rappel Deflector

Start Date: 6/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 6/29/10 Req'd Qty: 2.00

Customer:

Reference:

Run

Start



Approvals: Process Plan:

Date: 10-6-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4051

a

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube 50" and remove identification markings
2- Bend tube with manuel pipe bender as per template DT9574 (Make first line at 1.00")
3- Trim access tube material to finish size as per dwg D4051

SAD 10-06-28

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10.06.130

120

Identify as per dwg & Stock Location: basket

0.00



Packaging

Memo

0.00

Packaging

2 RD 10.07.01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Date:

QC:

Date:

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/01 JJ

ME

10-7-01

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Picklist Print

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Page 1

Work Order ID: 59998

Parent Item: D4051-1

Parent Item Name: Rappel Deflector



Start Date: 6/22/10

Start Qty: 2.00

Required Date: 6/29/10

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC IPP Rev:B as per dwg
REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.500W.049

Purchased

No

100

f

155.2554

4.1666

8.771789



Square Tubing



S40 10-06-29

Location

Loc Qty

Loc Code

MAT

148.1591158

114004

0

114426

9.2647

114807

138.894416

MAT018

4.4738

114004

0.5

114161

3.9738

WA

2.62251

114724

2.62251

8.771789

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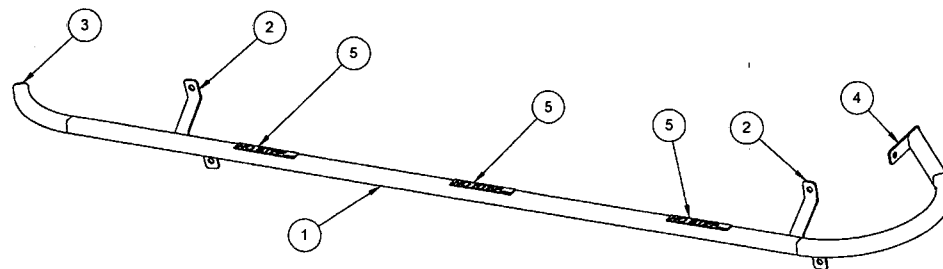
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 WITHOUT NOTICE
 WORK ORDER
 NO. 39998

RF 10-6-22



D4051-041 RAPPEL DEFLECTOR ASSY (SHOWN)
 D4051-042 RAPPEL DEFLECTOR ASSY (OPPOSITE)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D4051-041	RAPPEL DEFLECTOR ASSY
		X	D4051-042	RAPPEL DEFLECTOR ASSY
1	1	1	D4051-1	RAPPEL DEFLECTOR
2	2	2	D4051-3	BRACKET
3	1	1	D4051-7	FILLER
4	1	1	D4051-5	MOUNTING PLATE
5	3	3	D4051-9	PLACARD

RELEASED
 2010-02-16
JVP

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>RF</i>		
MFG. APPR.	<i>RF</i>		
APPROVED	<i>RF</i>		
DE APPR.	<i>RF</i>		
DATE	10.01.29		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4051** REV. A
 SHEET 1 OF 7

TITLE **RAPPEL DEFLECTOR ASSY** SCALE NTS

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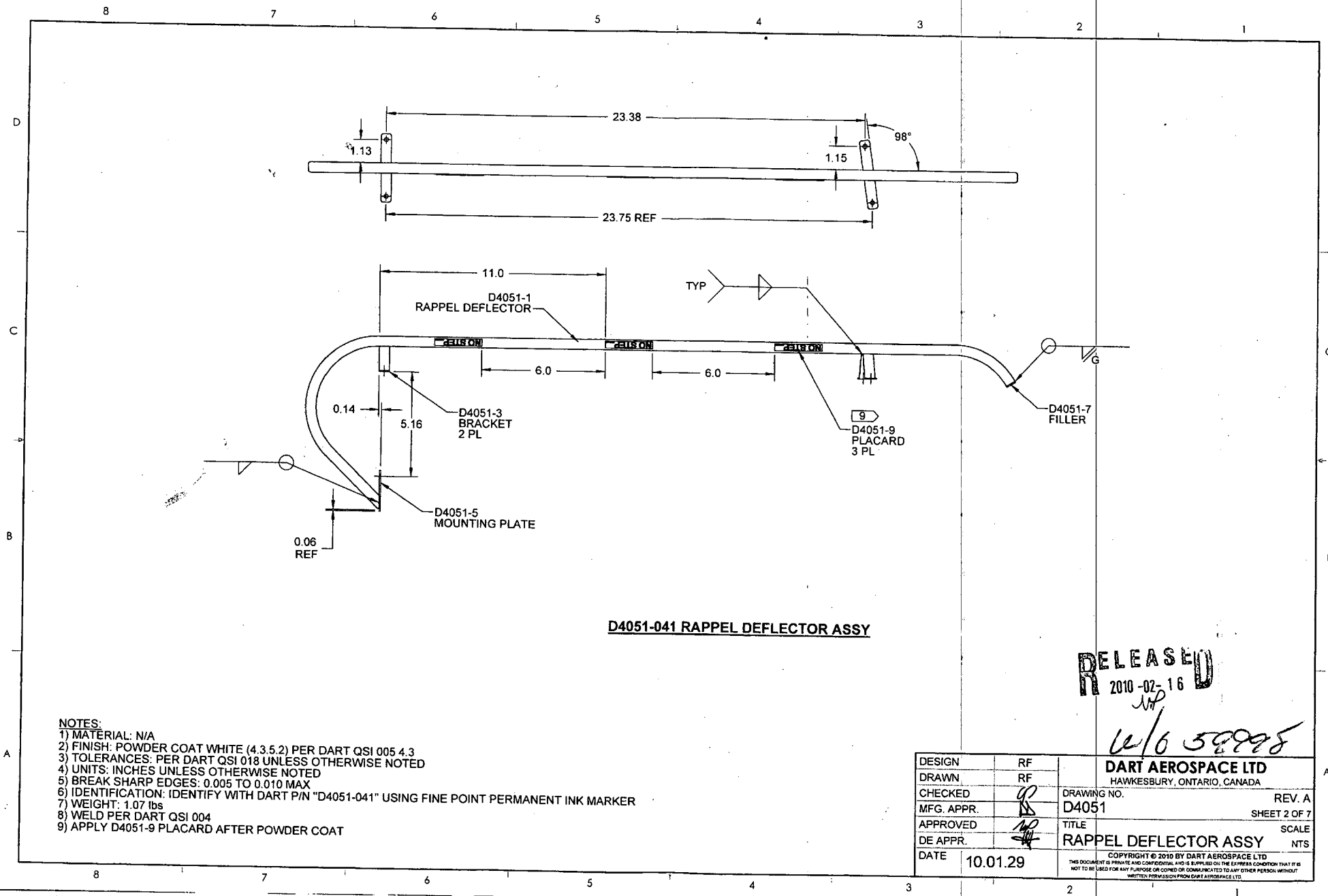
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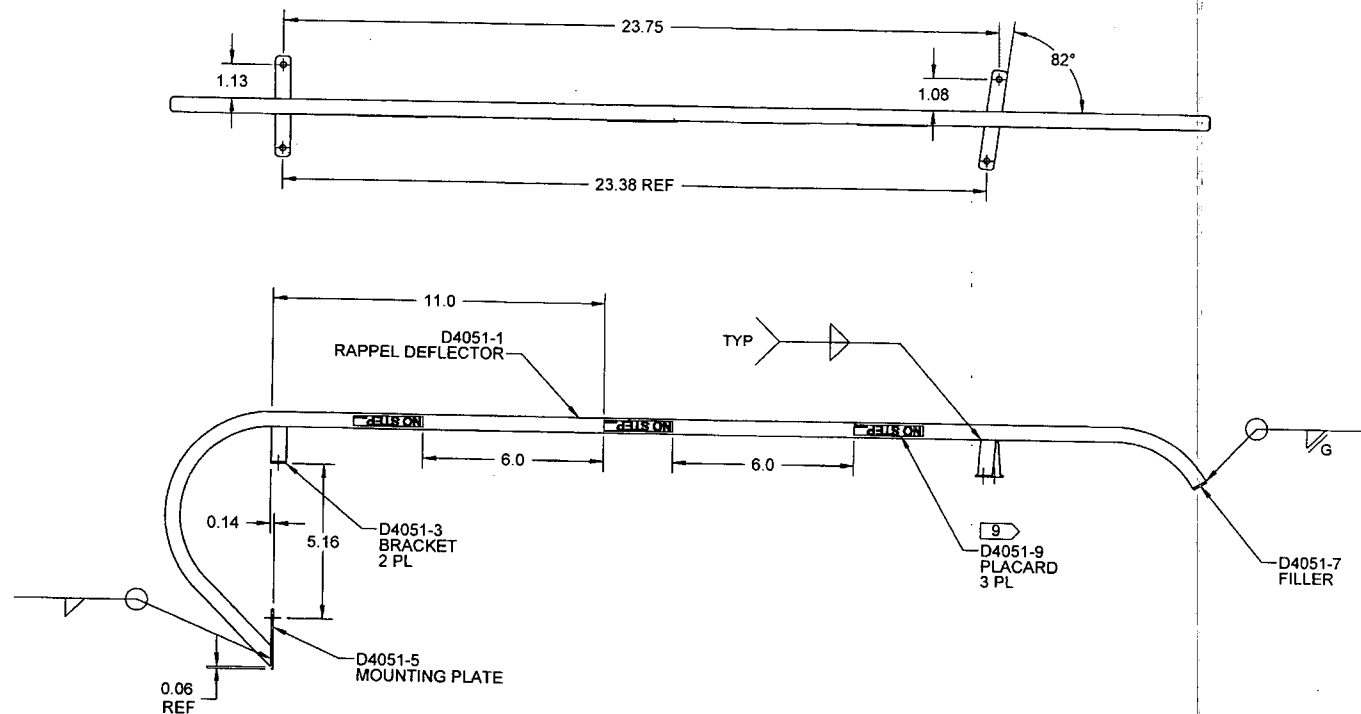
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D4051-042 CABLE DEFLECTOR ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4051-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.07 lbs
- 8) WELD PER DART QSI 004
- 9) APPLY D4051-9 PLACARD AFTER POWDER COAT

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2010-02-16

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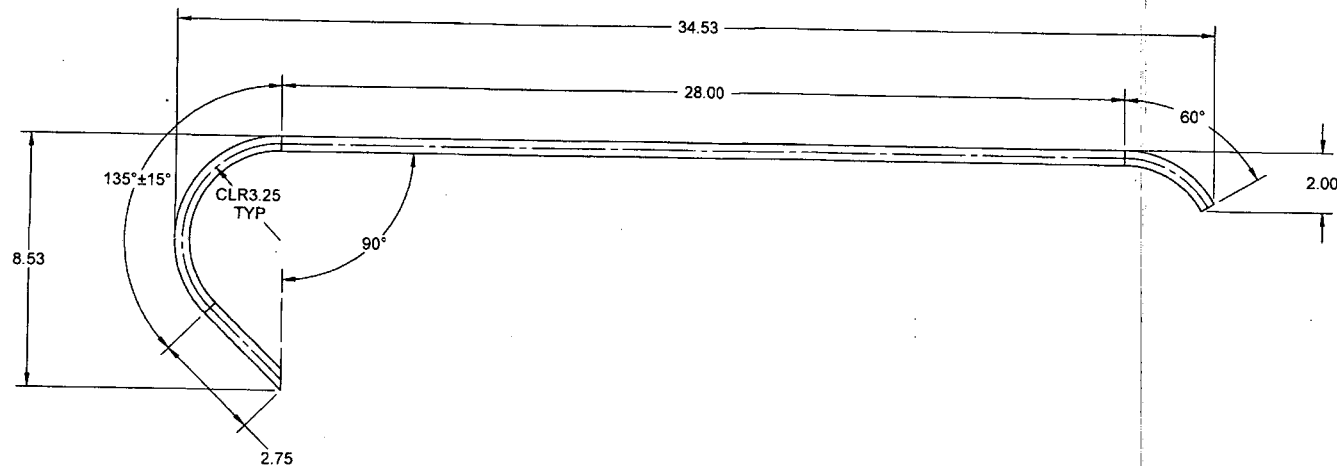
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8 D4051-1 RAPPEL DEFLECTOR

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.98 lbs
- 8) TUBE FLAT LENGTH 43.00 REF

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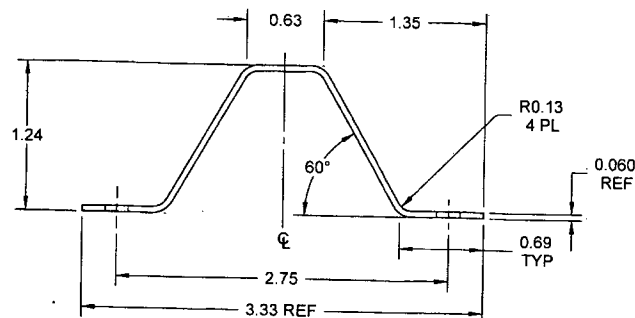
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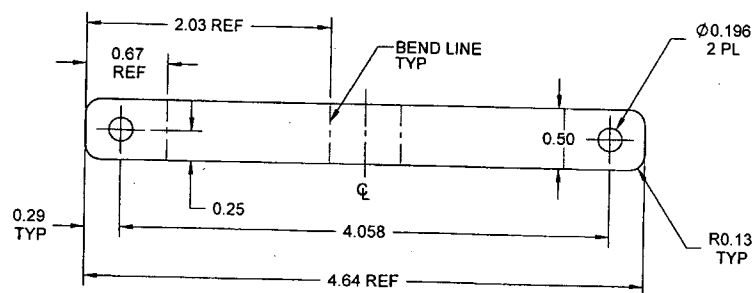
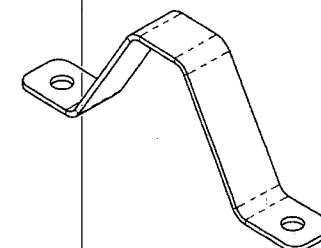
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D4051-3 BRACKET
(MAKE FROM D4051-3F FLAT PATTERN)



D4051-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 0.060 THICK ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

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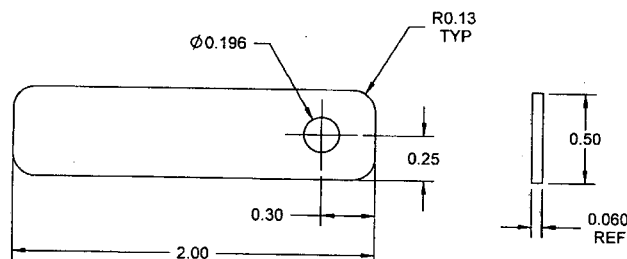
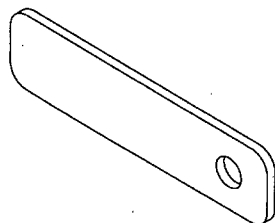
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

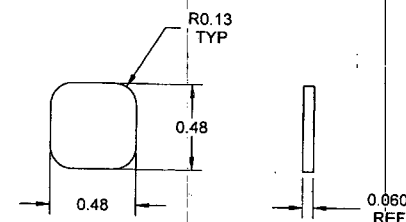
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D4051-5 MOUNTING PLATE



D4051-7 FILLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 0.060 THICK ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4051-5: 0.02 lbs
D4051-7: 0.004 lbs

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DE APPR.	RF		
DATE	10.01.29		

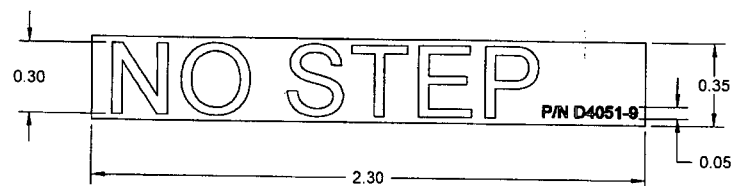
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D4051-9 PLACARD

NOTES:

- 1) MATERIAL: RED LETTERS ON WHITE BACKGROUND AND SELF-ADHESIVE BACK.
MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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2010-02-16
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u/c 58895

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